

Date:  
User:Wednesday, 3/8/2006 10:47:23 AM  
Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: PEDAL ARM
Job Number	: 26153		
Estimate Number	: 10868		
P.O. Number	: <i>N/A</i>	Part Number	: D32061
This Issue	: 3/8/2006	S.O. No.	: <i>N/A</i>
Prsht Rev.	: NC	Drawing Number	: D3206 REV A
First Issue	: <i>N/A</i>	Project Number	: N/A
Previous Run	: 25965	Drawing Revision	: A
	Type : PURCHASED PARTS	Material	: <i>N/A</i>
Written By	: <i>See comment below</i>	Due Date	: 3/28/2006
Checked & Approved By	: <i>FF 06.03.08</i>	Qty:	<i>12</i> Um: Each
Comment	: Est. A 04.04.15 New issue KJ/RF		

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 PG PURCHASING



## Comment: PURCHASING

Issue P/O: *765*  
 Email or Ship DXF file to vendor  
 Laser Cut D3206-1 as per Dwg D3206  
 Material release note is required

*4 06-23-09*  
*(12)*

2.0 D32061F Pedal Arm



Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)  
 Pedal Arm

3.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1  
 Recieve & Inspect for Transit Damage  
 Ensure Material Release Note is attached

*6/4/3 (12)*

4.0 QC6 DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

*06-04-06*  
*12*

5.0 SMALL FAB 1 SMALL &amp; MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1  
 Deburr if necessary

*FF 06.04.06*  
*12*

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA:   *SD*   Date: 06/04/13

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Wednesday, 3/8/2006 10:47:23 AM  
User: Kifn Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PEDAL ARM

Job Number: 26153

Part Number: D32061

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

*A.M 06-04-12*

*(12)*

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

*FC*

*06 04 12*

*(12)*

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

*5/4/12*

*06/4/12*

*(12)*

9.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

*06/04/13*

Job Completion



*06-04-13*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

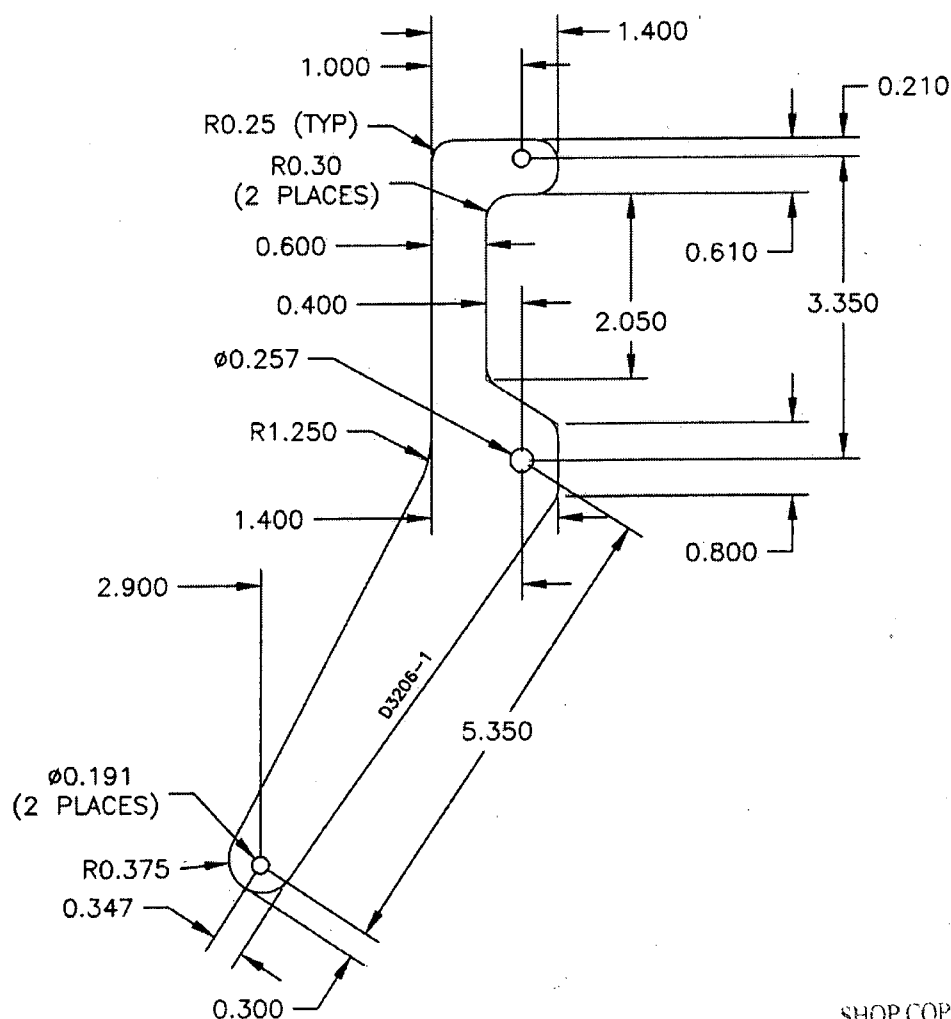
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3206	REV. A SHEET 1 OF 1
DATE 04.01.27		TITLE PEDAL ARM	SCALE 1:2
A	04.01.27	NEW ISSUE	

RELEASED  
04.04.05



NOTES:

- 1) BREAK ALL UNMARKED SHARP CORNERS 0.005 TO 0.010
- 2) MATERIAL: AISI 4130N SHEET, 11 GAUGE (M4130N-S125)
- 3) FINISH POWDER COAT GREY SANDEX (REF. 4.3.5.6) PER DART QSI 005.4.3
- 4) ENGRAVE DART P/N AS SHOWN
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY  
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WITHOUT NOTICE  
WORK ORDER  
NO. 26153

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# CERTIFICATE OF TEST

P.O. 765

DATE: *Mar 22/06*  
LABORATORY: *L. Lawrence*

CUSTOMER ORDER NUMBER

10038

CUSTOMER PART NUMBER

Note: This report is valid only for the material described herein and is not valid for any other material. DOT release certificate or certificate of conformance.

BOLD TO: DEMEL AIRCRAFT CORP  
101 3440 AIRPORT ROAD  
PENTICTON BC V2A 8X1

SHIP TO: DEMEL AIRCRAFT  
C/O BETTA'S SERVICES  
1306 MAIN STREET  
OROVILLE WA 98844

Description: 4130 CR AQ OILED SHEET COND N  
125 X 36 X 144"  
HEAT: 2122580

AMS 6345  
Line Total: 183.6 LB

ITEM: 508694

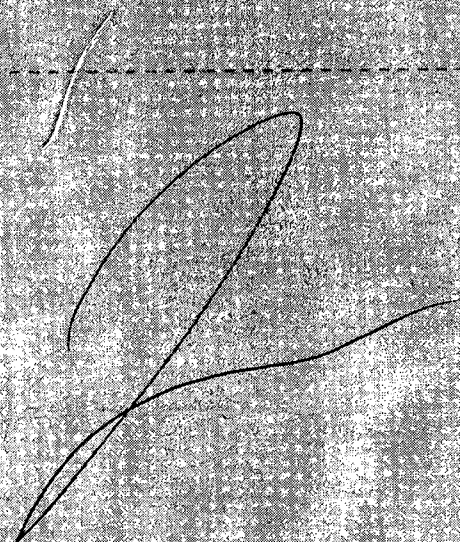
MATERIAL IS FREE FROM MERCURY CONTAMINATION

DECARB: OK

AMS NO: 2301

SEVERITY: 0.01

FREQUENCY: 0.02



The above data were transcribed from the manufacturer's Certificate of Test after verification for completeness and specification requirements of the information on the certificate. All test results remain on file subject to examination.

We hereby certify that the material covered by this report will meet the applicable requirements described herein, including any specification forming a part of the description.

The willful recording of false, fictitious, or fraudulent statements in connection with test results may be punishable as a felony under federal statutes.

Material did not come in contact with mercury while in our possession.

MELINDA ENDRES



LABORATORY QUALITY ASSURANCE



P.O. 765

RELEASE CERTIFICATION

THIS REPORT CONTAINS INFORMATION OF A CONFIDENTIAL NATURE AND IS NOT TO BE RELEASED TO THE PUBLIC OR TO ANY OTHER PERSON WITHOUT THE WRITTEN AUTHORIZATION OF THE BUREAU OF CHEMISTRY

Date: *Mar 22/96*  
 AUTHORIZED BY: *Franklin*

Note: Items which are shown with an "X" have not been tested and are not covered by this report. Items are certified as conforming to specification.

**CERTIFICATE OF TEST**

CUSTOMER ORDER NUMBER

10110

CUSTOMER PART NUMBER

OLD TO: DEMEL AIRCRAFT CORP  
 101 3440 AIRPORT ROAD  
 PENTICTON BC V2A 8X1

SHIP TO: DEMEL AIRCRAFT  
 C/O BETTA'S SERVICES  
 1306 MAIN STREET  
 OROVILLE WA 98844

Description: 4130 HR DESCALED AQ PLATE AMS 6345  
 1/16" 30.000" X 74.000" RECTANGLE REMNANT Line Total: 118 LB  
 HEAT: C0007 ITEM: 508730

Specifications:  
 MIL S 18729 COND N C\* AMS 6345 96 UNS G41300  
 AMD 1 AMS 2301 H

CHEMICAL ANALYSIS

C	MN	P	S	CU	SI	NI	CR
0.31	0.52	0.008	0.003	0.15	0.25	0.09	0.91
MO	V	AL	CB				
0.19	0.049	0.022	0.001				

CPT: R983907  
 MILL: BETHLEHEM STEEL CORP COUNTRY OF ORIGIN: USA

MECHANICAL PROPERTIES

DESCRIPTION	YLD STR PSI	ULT TEN PSI	%ELONG IN 02 IN	%RED IN AREA	HARDNESS
	94500.0	120900.0	19.0		

DEVELOPED HARDNESS 042 RC

BEND: Y

GRAIN SIZE : 7 - 8

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The willful recording of false, fictitious, or fraudulent statements in connection with test results may be punishable as a felony under federal statutes.

Material did not come in contact with mercury while in our possession.

MELINDA ENDRES

*Franklin*  
 MANAGER, QUALITY ASSURANCE